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D2564**Job Sheet 209920****Part No:** D2564**Job Qty:** 11 pcs**Part Name:** Mounting Angle**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/15/20**Job Tracking No:****Due Date:** 5/22/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV B1 IPP: D 02.09.09 Re-format; Added FA276 Folio KJ/RF**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	11 pcs	5/21/20	5/21/20	0.00	0.28	Bandsaw - 1		B.e 20-05-16
110	HAAS 4 Axis - B4B	11 pcs	5/22/20	5/22/20	1.00	0.73	HAAS - 1 - B4B		B.e 20-05-16
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	11 pcs	5/22/20	5/22/20	0.00	0.00	QC 8 - 12		mk 20/05/19
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		

**Container No:** S278164**Part:** D2564**Job No:** 209920**Serial No/Batch:** S278164**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140	Packaging 3-1 - Stock - B4B 11 pcs	5/22/20	0.00 0.00	Packaging 3 - 1 - B4B	CC
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150	QC 21 - SA 11 pcs	5/22/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-00
Part Op 100 - (Bandsaw)Cut D6207 Extrusion: 1.00" Long Descriptions: 110 - (HAAS CNC vertical machine #1)1- Mill as per Folio FA276 Rev: <u>AA</u> & Dwg D2564 Rev: <u>B</u> 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location: _____) *** STOCK IN STEP CELL*** 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6A1.000W.125	6061T6 Angle 1.00 X 1.00 X .125W	1.0076 ft (.0916 ea)	100-Bandsaw - 1	5123412 (	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6A1.000W.125	1	6	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Angle	1.000inches $\pm$ 0.030	1.030 0.970	1.000	
2	Mounting Angle	0.625inches $\pm$ 0.010	0.635 0.615	0.624	
3	Mounting Angle	0.257inches $\pm$ 0.010	0.267 0.247	ϕ 0.258	
4	Mounting Angle	1.000inches $\pm$ 0.010	1.010 0.990	1.000	
5	Mounting Angle	1.000inches $\pm$ 0.010	1.010 0.990	1.000	
6	Mounting Angle	0.375inches $\pm$ 0.010	0.385 0.365	R0.375	

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____ Date: _____		Sequence #: _____ QTY Affected: _____		DEPARTMENT/PROCESS Eng. (Non-AW) _____ Prod. Eng. Coord. _____ Rec/Store/Packaging _____		Engineering _____ Water Jet _____ Supplier _____ Quality _____ MRB (QS1042) _____	
Description Work Order Deviation				Disposition			
Root Cause Operator _____ Manufacturing Process _____ Equip/Tooling _____ Handling/Preservation _____ Material _____ Product Improvement _____ Process Improvement _____ Human Factors _____ Pressure/Forced _____ Bending _____ Crushing _____ Cracks _____ Crimp/Kink/Ripple/Wave/Twist _____ Marks/Chatter _____ Mislabeled _____ Other/Details: _____				FAULT CATEGORY Contamination _____ Misaligned/off center _____ BOM/Route _____ Broken/Damage/Defect _____ Incomplete/Unclear Instructions _____ Drill Holes _____ Fit/Function _____ Power Loss/Surge _____ Folio/Program _____ Grain Direction _____ Weld _____ Wrong Stock Pulled _____ Out of Sequence _____ Off-set/Set-up _____			
				Positioned Wrong _____ Outside Tolerance _____ Drawing _____ Finish _____ Part Lost/Missing _____ Misread _____			
				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____			